

# Work Order ID 82641

April-04-12 10:52:06 AM

**\*82641\***

Page 1

Item ID: D4271-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: End Fitting Assembly Fwd Beam  
 Start Date: 04/04/2012 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 30/04/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: MJ Date: 12/04/09 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4271	D								
100		0.00							
<b>*100*</b>									
Small Fab									
Small Fab	Memo	0.00							
	Assemble as per dwg D4271								
	REAM HOLE AS PER DWG								
	CUT RIVET AT 1.130"								
	C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC									
Quality Control	Memo	0.00							
120	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
<b>*120*</b>									
Packaging									
Packaging	Memo	0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

April-04-12 10:52:06 AM

**Item ID:** D4271-025

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Revision ID:

**Item Name:** End Fitting Assembly Fwd Beam

Stop **\*NS2\***

**Start Date:** 04/04/2012      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 30/04/2012      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

**Tool ID**

Tool #

**Plan  
Code**

**Accept  
Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

## Memo

0.00

## Quality Control

12/5/14  
ME  
12-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 82641

\*82641\*

Parent Item: D4271-025

\*D4271-025\*

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4149-5 *D4149-5* Eyebolt Stud		Manufactured	No			100	Each	18.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST133				18					
				79057				6					
				81403				12					
D4419-1 *D4419-1* Fwd Support Plate		Manufactured	No			100	Each	0.0000	2	8			
				<u>Location</u>				<u>Loc Qty</u>					
				ST				-12					
				ST139				4					
D4281-1 *D4281-1* Spacer		Manufactured	No			100	Each	13.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST139C				13					
				71930				13					
D4281-3 *D4281-3* Spacer		Manufactured	No			100	Each	4.0000	1	4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST139A				4					
				80752				4					

\*\*

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EB 12/05/09  
383888  
EB 12/05/09  
383888  
EB 12/05/09  
383888  
EB 12/05/09  
383888

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 82641

Parent Item: D4271-025

Parent Item Name: End Fitting Assembly Fwd Beam

\*82641\*

\*D4271-025\*

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

AN4C13A

Purchased

No

100

Each

179.0000

2

8

\*\*

\*AN4C13A\*

BOLT

Location

Loc Qty

Loc Code

ST307

100

121166

100

ST357

79

120187

1

120423

78

MS20427M4-20

Purchased

No

100

Each

172.0000

1

4

\*\*

\*MS20427M4-20\*

RIVET

Location

Loc Qty

Loc Code

GA

172

118429

172

MS20615-4M18

Purchased

No

100

Each

244.0000

10

40

\*\*

\*MS20615-4M18\*

Rivet

Location

Loc Qty

Loc Code

ST323

244

118077

80

118543

164

EP 12/05/09  
2 M12/444  
2  
4  
40  
40

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries



# Picklist Print

April-04-12 10:52:10 AM

Page 3

Work Order ID: 82641

**\*82641\***

Parent Item: D4271-025

**\*D4271-025\***

Parent Item Name: End Fitting Assembly Fwd Beam

Start Date: 04/04/2012

Required Date: 30/04/2012

Start Qty: 4.00

Required Qty: 4.00

MS21043-4

Purchased

No

100

Each

1,874.000

2

8

**\*MS21043-4\***

\*\*

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1834

119546

360

120308

474

121162

1000

NAS1149C0432R

Purchased

No

100

Each

5,220.000

4

16

**\*NAS1149C0432R\***

\*\*

Washer

Location

Loc Qty

Loc Code

ST297

2220

117291

1220

119124

1000

ST298

3000

121255

3000

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

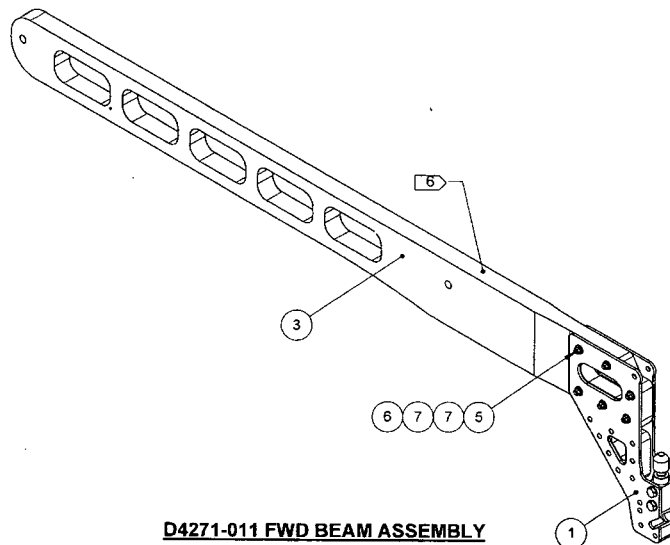
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

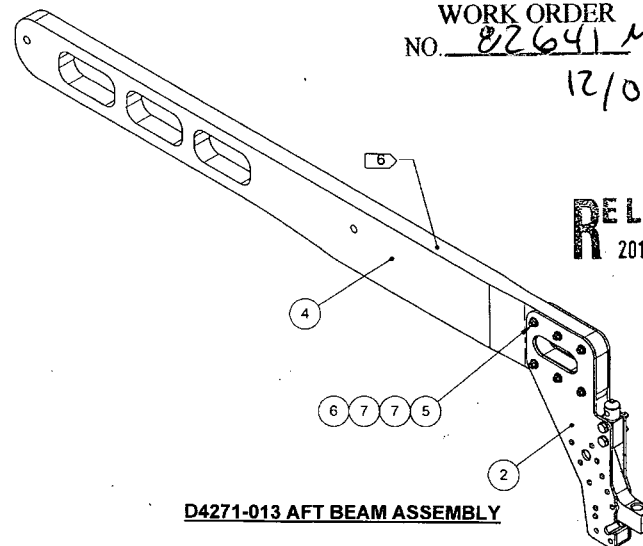
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

**NOTE:** Date & initial all entries

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



**D4271-011 FWD BEAM ASSEMBLY**



**D4271-013 AFT BEAM ASSEMBLY**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 82641 MJS  
12/04/04

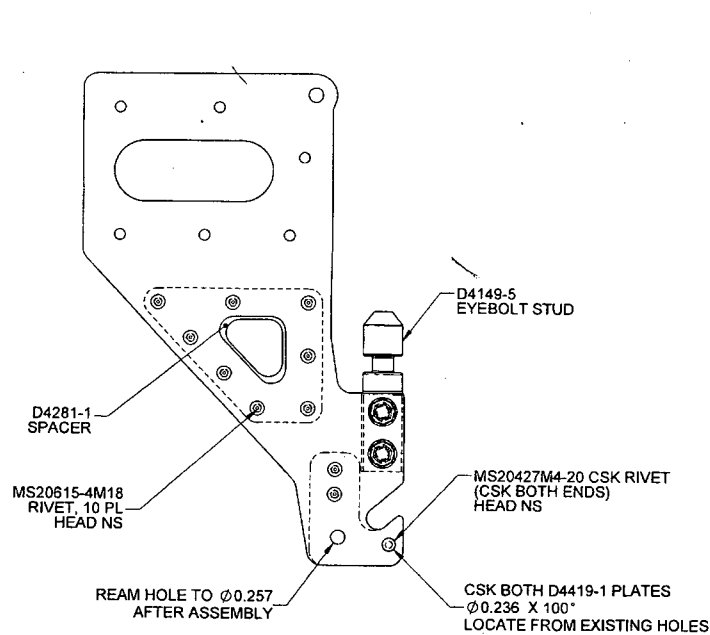
**RELEASED**  
2011-07-28

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"  
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs  
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. D
MFG. APPR.	E	D4271	SHEET 1 OF 3
APPROVED	140	TITLE	SCALE
DE APPR.	#	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

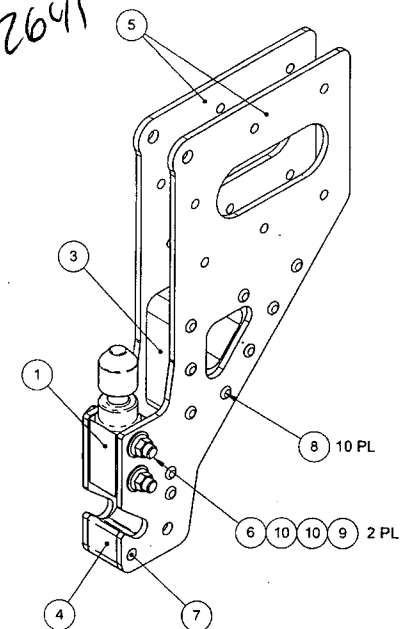
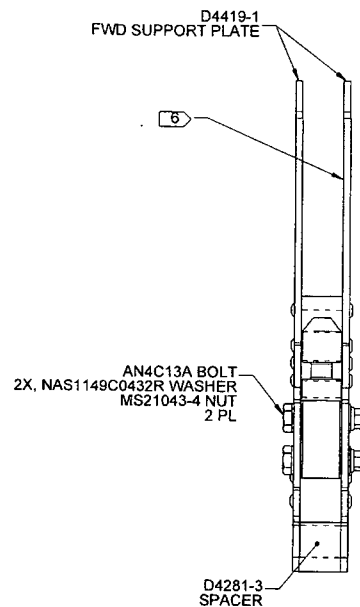
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



**D4271-025 FWD BEAM END FITTING ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs

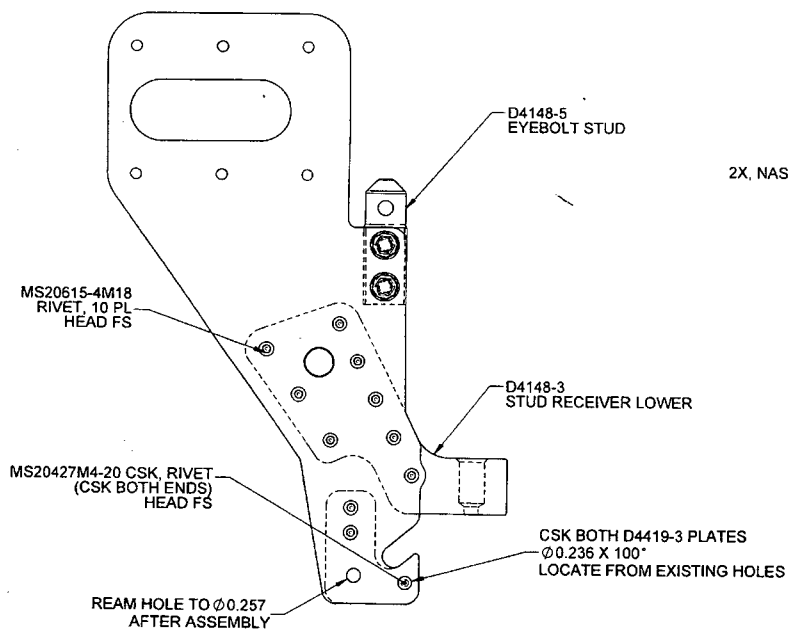


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2011-07-28

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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		<b>D4271</b>	SHEET 2 OF 3
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82641

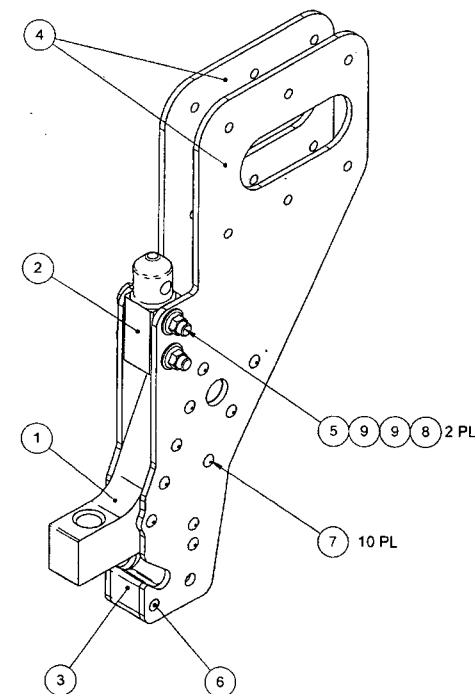
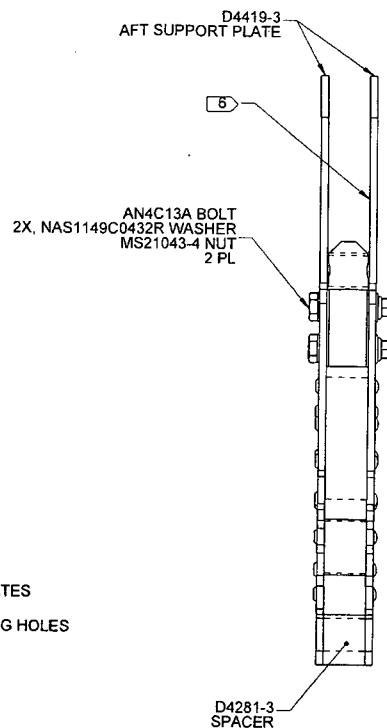
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



### D4271-027 AFT BEAM END FITTING ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



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MFG. APPR.	<i>[Signature]</i>	<b>D4271</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>SUPPORT BEAM ASSEMBLIES</b>	
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